

Work Order ID 148542

Tuesday, July 05, 2016 3:02:46 PM

148542

Page 1

Item ID: D2530 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Handle Weldment
 Start Date: 7/25/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/4/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: JUL 12 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2530	Rev B ✓								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.14							
Small Fab	1-Cut to length as per Dwg D2536 2-Deburr								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Weld per dwg A/R S.S. rod Batch: <u>134992</u>	0.00							
120									
Large Fab	Memo	0.13							
Large Fab	1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301								

OCT 21 2016

DAS
38

OCT 24 2016

18-12-01

Jm

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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Item ID: D2530

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Handle Weldment

Start Date: 7/25/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/4/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampDAS
18
9-89

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

4 0 16-12-01

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.01

Quality Control

② 16-12-01

DAS
9
9-89

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.01

Powder Coating

M 124777

START TIME: 8:25

OVEN TEMPERATURE: 320°

FINISH TIME: 8:55

4 0 16-12-05

DAS
34
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Page 3

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Required Date: 8/4/2016 Req'd Qty: 4.00 ***4*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				4			DAS 38 9-89 DEC 05 2016
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST379</u> Memo	0.00 0.01				4			DAS 6 9-89 DEC 05 2016
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							16/12/6 AJ mf 16-12-06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
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		OTHER : _____							

Picklist Print

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Page 1

Work Order ID: 148542

148542

Parent Item: D2530

D2530

Parent Item Name: Handle Weldment

Start Date: 7/25/2016

Required Date: 8/4/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F
11.01.07 chg qc 5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2534		Manufactured	No			120	Each	61.0000	2	8			
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D2534

Lock Plate

**

16-12-01
JML

Location	Loc Qty	Loc Code
WA004 149123	61	
139017 152297	1	
145921	60	

M304TR0.750W.049	Purchased	No			100	f	183.9928	2.9145	12.27158				
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M304TR0 750W 049

304 RD Tube .750 x .049W

**

FF OCT 21 2016

not Pulled

Location	Loc Qty	Loc Code
GA002 135242	178.4200852	
M132270	0.00001	
M133131	0.0007242	
M133509	14.210211	
M133700	2.794323	
M133914	5.98516	
M134138	1.1364496	
M134212	8.5144235	
M134306	10.6695789	
M134528	3.7518392	
M134604	49.23105	
M134824	29.650527	
M134993	12.4757888	
M135093	40	

MAT	5.5727347	
M133400	5.5727347	

135709

3.067875

3.1

This one not Pulled
not in system

9.203685

9.2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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OTHER : _____					

DART AEROSPACE LTD		Work Order:	148542
Description: Handle Weldment		Part Number:	D 2530
Inspection Dwg: D2530 Rev: B		Page 1 of 1	

INSPECTION SHEET

[illegible]

Engineering Approval: (If necessary)		Date:	
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